



Dart Aerospace Ltd.
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D4776-5
Job Sheet 182187



Part No: D4776-5

Job Qty: 100 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/20/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D SHEET 3 IPP REV:A NEW ISSUE 13-08-30 JLM VERIFIED BY:DD IPP REV:B 13.09.26 AS
PER REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	100 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Machining-3		
100	Doosan	100 pcs	9/7/18	9/7/18	0.05	5.58	Doosan		
120	QC	100 pcs	9/7/18	9/7/18	0.00	0.00	QC8		
130	HandFinish	100 pcs	9/7/18	9/7/18	0.00	0.49	HandFinish1		
140	QC	100 pcs	9/7/18	9/7/18	0.00	0.00	QC7-4		
150	Packaging	100 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-2		
160	QC21-SA	100 Ea	9/7/18	9/7/18	0.00	0.00	QC21		

Part Op
Descriptions: 100 - 1-Turn as per Folio and Dwg

DWG
21
9-88

OCT 10 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.500	6061-T6 Round Bar .500"	2 ft (.02 ea)	90-Start up Operation	FH138109.0

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.500	2	30	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.130Inches ± 0.030	0.160 0.100		
2	Spacer	0.250Inches ± 0.030	0.280 0.220		
3	Spacer	0.625Inches ± 0.010	0.635 0.615	Diameter	
4	Spacer	0.438Inches ± 0.010	0.448 0.428	Diameter	
5	Spacer	0.203Inches ± 0.005 - 0.001	0.208 0.202	Diameter	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA

W

Dat

Work Order update only ☐

JARI
AEROSPACE
 Container No: S116190
 Part: D4776-5
 Job No: 182187
 Serial No/Batch: S116190
 Revision:
 Inspector:
 Exp Date:
 Instructions: Various STC's

Date: 10/05/18

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 CANADA
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 www.dartaerospace.com

AGAINST DEPARTMENT/PROCESS

Cross tube	☐	Water Jet	☐	Engineering	☐
Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Composite	☐	Supplier	☐		

MRB (QSI042) Approval

Disposition

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

☐ Pressure/Forced
☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Wave/Twist in Tube
☐ Marks/Chatter

FAULT CATEGORY

☐ Temperature/Cure
☐ Set-up
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Inspection Incomplete/Unqualified
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Instructions Incomplete/Unclear
☐ Drill Holes

☐ Power Loss/Surge
☐ Folio/Program
☐ Grain
☐ Weld
☐ Wrong Stock Pulled
☐ Out of Sequence
☐ Off-set
☐ Misabeled
☐ Fit/Function
☐ Misaligned/off center

☐ Positioned Wrong
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Drawing
☐ Finish
☐ Misread
☐ Turning Sequence

OTHER :